

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019738**Date Inspected:** 01-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 14, OBG (NWIT # 7567)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3013H-001

SEG3013H-002

SEG3013J-122

OBG TRIAL ASSEMBLY, OBG Segment 11DE-11EE

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: 12012010-1) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between two deck panels at intersection of OBG segment 11DE & 11EE. The weld designations were as;

WELDING INSPECTION REPORT

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OBE11A-008 (11DE-11EE DP-A1)

OBE11A-009 (11DE-11EE DP-A2)

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

SEGMENT 13AE

Repair welding by SMAW process of weld joint SEG3007P-042 joining Floor Beam (FB) 3106 to Longitudinal Diaphragm (LD) at panel point (PP) 118 of segment 13AE. Welder is identified as 216086. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR-1.

SEGMENT 13CE

Repair welding by SMAW process of weld joint SEG3011K-161 joining Floor Beam (FB) 3149B to Longitudinal Diaphragm (LD) 3029 at panel point (PP) 122.5 of segment 13CE. Welder is identified as 043661. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1.

SEGMENT 14E (B-CWR2234)

Repair welding by FCAW (ESAB) process of weld joint SEG3091AB-091 joining Longitudinal Diaphragm (LD) 3042A to Bottom plate of segment 14E. Welder is identified as 062782. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-ESAB-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
